

Date: Wednesday, 22/10/2008 4:08:44 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : UPPER RAIL
Job Number : 42874	
Estimate Number : 13489	
P.O. Number :	Part Number : D37671
This Issue : 22/10/2008 S.O. No. :	Drawing Number : D3767 REVB
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 40866	Material :
Written By :	Due Date : 07/11/2008 Qty: 12 Um: Each
Checked & Approved By : <u>JUD 08.10.22</u>	
Comment : Est Rev:A 08-07-21 revB as per dwg DD verified by:EC Est Rev:B Added drilling tooling 08-08-26 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T1000W065	6061T6 RD TUBE 1.00 x .065w
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(12x)

Comment: Qty.: 2.9313 f(s)/Unit Total: 35.1754 f(s)
 6061T6 TUBE (1.00" x 0.65" wall)
 batch: M 110778

M-1 09/02/09

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-cut tube to length as per dwg D3767

2-drill holes thru to finish size as per dwg D3767 Using DT9410, Locate tube on stop labelled #2 and then drill holes labelled #2

3- deburr

M-1 09/02/10 (12x)
09/02/09
PCU

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

09/02/10 (+12)

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

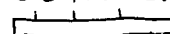

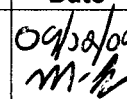

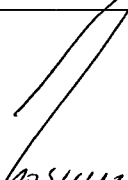
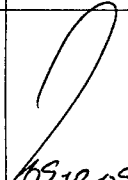
Chemical Conversion Coat as per QSI 005 4.1

M 09-02-10 PCU

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3767-1 PAR #: N/A Fault Category: Prod / Pass NCR: (Yes) No DQA: S Date: 09/02/11
D412-769-043 QA: N/C Closed: D Date: 09/02/11

NCR: <u>42874</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-02-09	2.2	1 part scrap. Holes were drilled opposite to aug when the tube was flipped to drill the other side. <div style="text-align: center;">  </div> Ex. R.C. Human error.	 OSIMZ	Scrap & replace Qty 1 M# <u>110778</u>	09/02/09  M-H	 09/02/10	 OSIMZ	 09-02-09

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UPPER RAIL

Job Number: 42874

Part Number: D37671

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F2 09/02/10

(12)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST246

JS

09/02/10

(12)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/11

Job Completion



MF 09-02-10

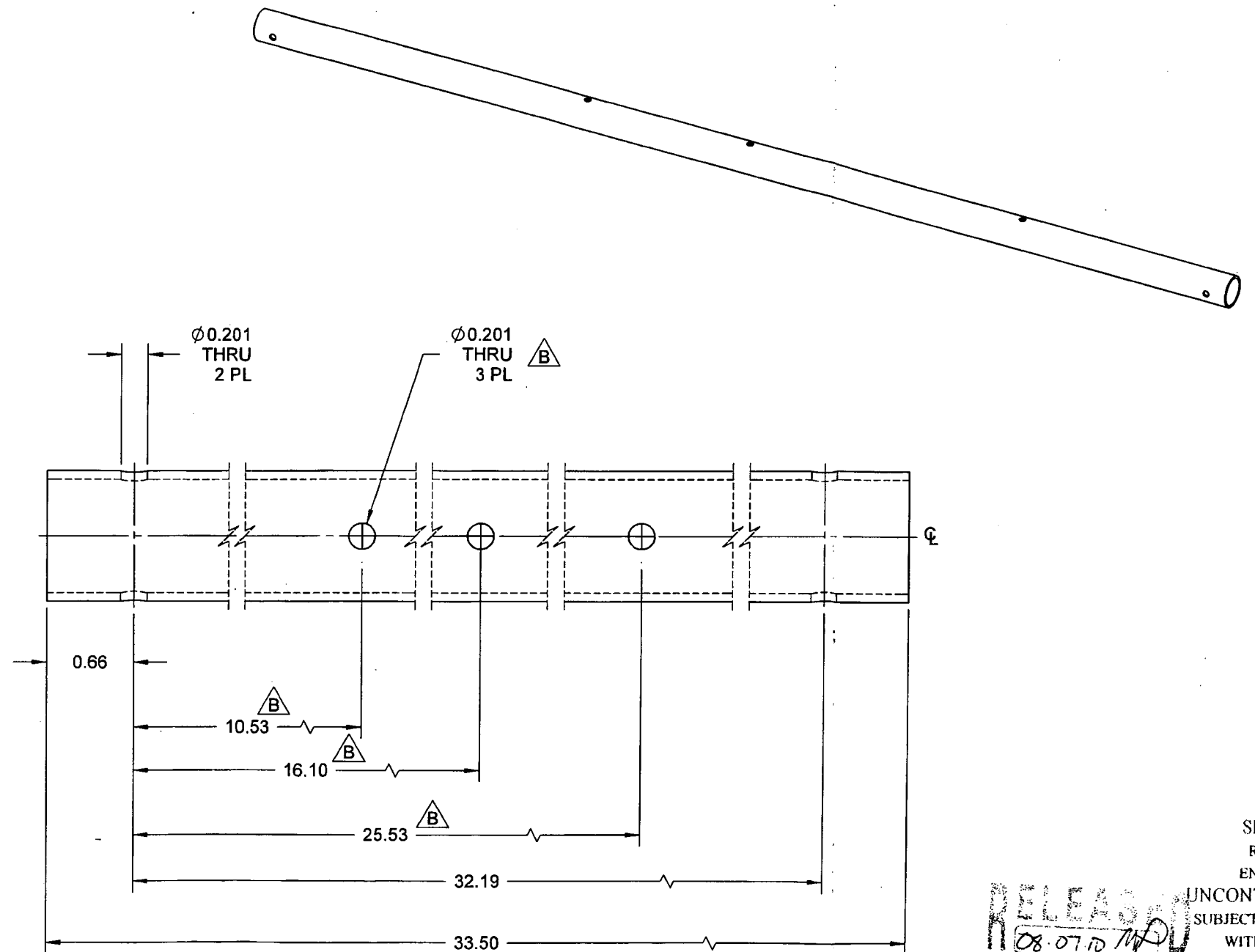
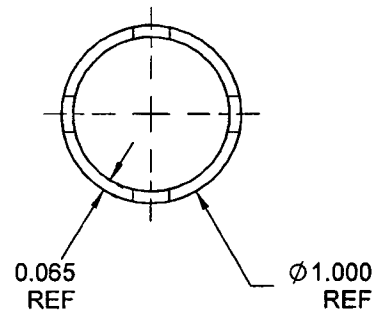
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3767-1 UPPER RAIL

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" OD X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR AMS-QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.62 lbs

B	CHANGE HOLE SIZE TO 0.201, SHIFT HOLES FOR ATTACHING FRAME BY 0.125, ADD HOLE AT 16.10	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3767	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		UPPER RAIL	NTS
DATE	08.06.23	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED
08.07.10

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WORK ORDER NO. 42874